

Date: Monday, 7/9/2007 2:29:14 PM
User: Kim Johnston

Process Sheet

5817

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION
Job Number : 33420
Estimate Number : 10326
P.O. Number : N/A
This Issue : 7/9/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 33136
Written By :
Checked & Approved By :
Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

Part Number : D27317
Drawing Number : D2731 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 7/20/2007
Qty: 50 Um: 100 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s)
Lug Extrusion D2423
Batch: B23779

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut D2423 extrusion to .82" Batch

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per folio D2731-7.
2-Check for crack while loading into the machine.
3-Tumble
4-Deburr any rough edges after tumbling

Issue P.O. 4191 Machine per ~~std~~ drawing D2731 Rev.B

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC3 SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: FD Date: 07/08/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 33420

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



50x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/08/22

7.0

POWDER COATING

POWDER COATING



50

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

BR/PR

07-08-22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Er 07/08/22

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/8/22 SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



50

Comment: FINAL INSPECTION/W/O RELEASE

07/08/22

Job Completion



U 7.08.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

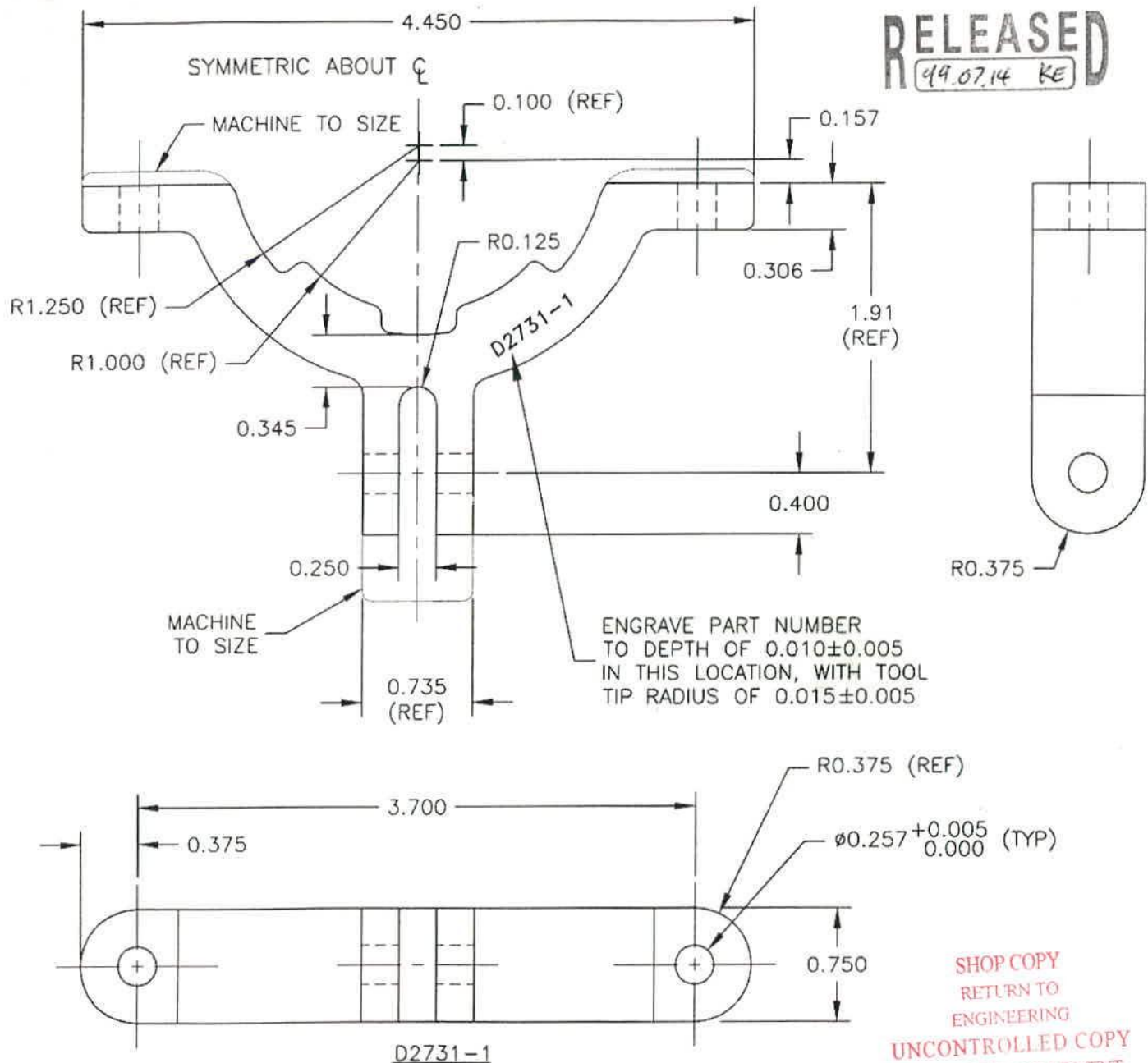
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	

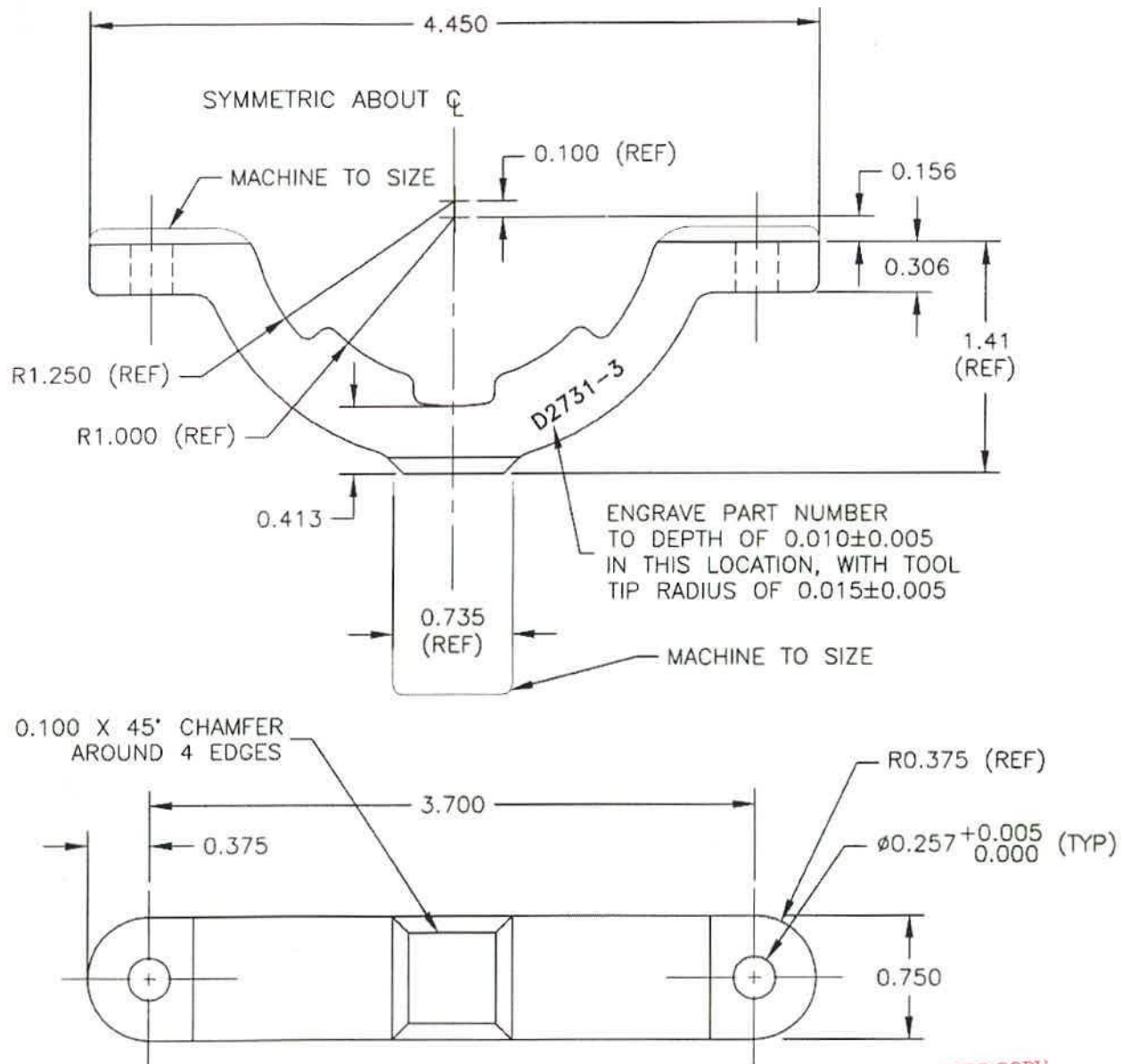


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33420

DART

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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

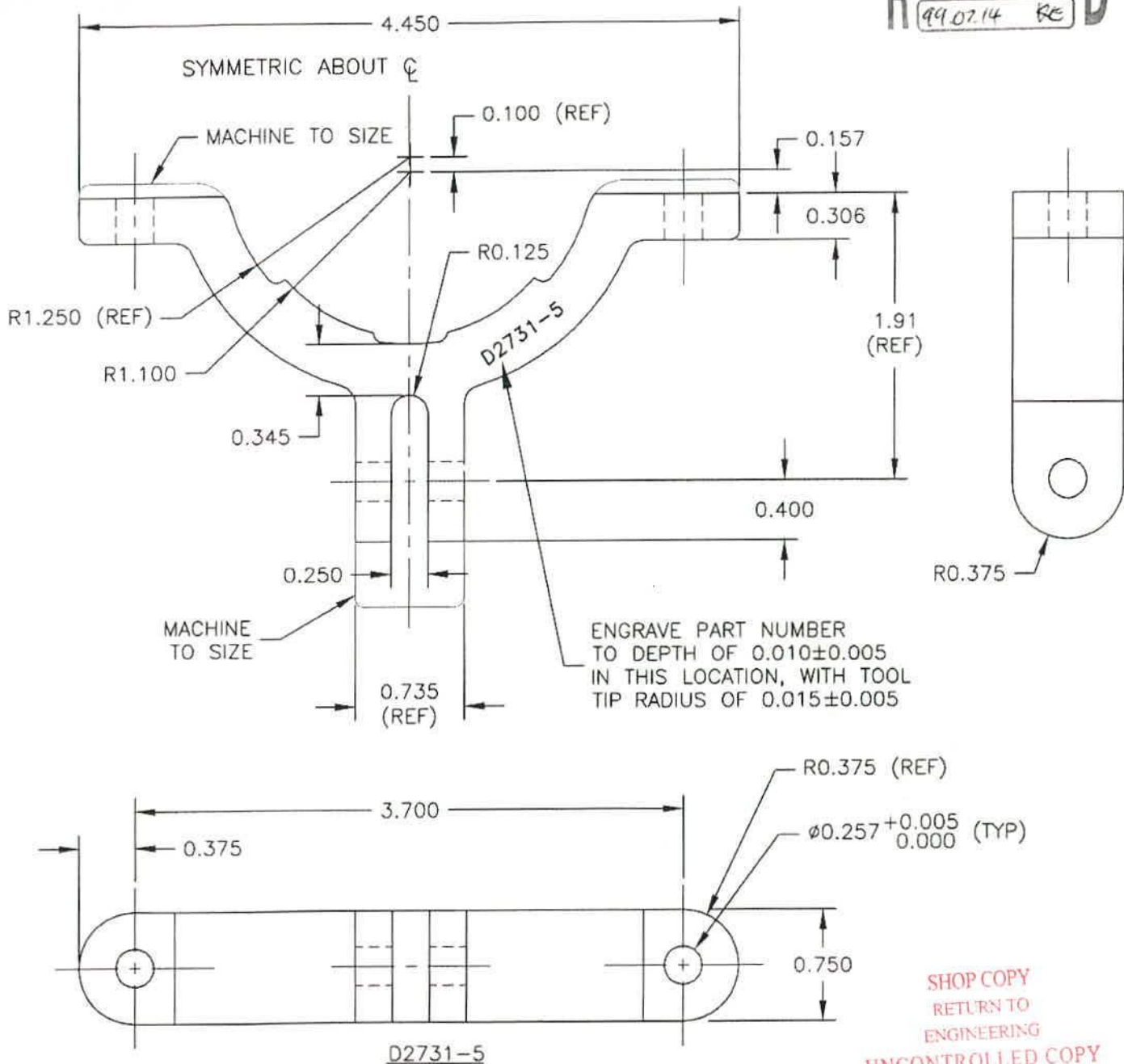
RELEASED
99.07.14 *KE*

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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

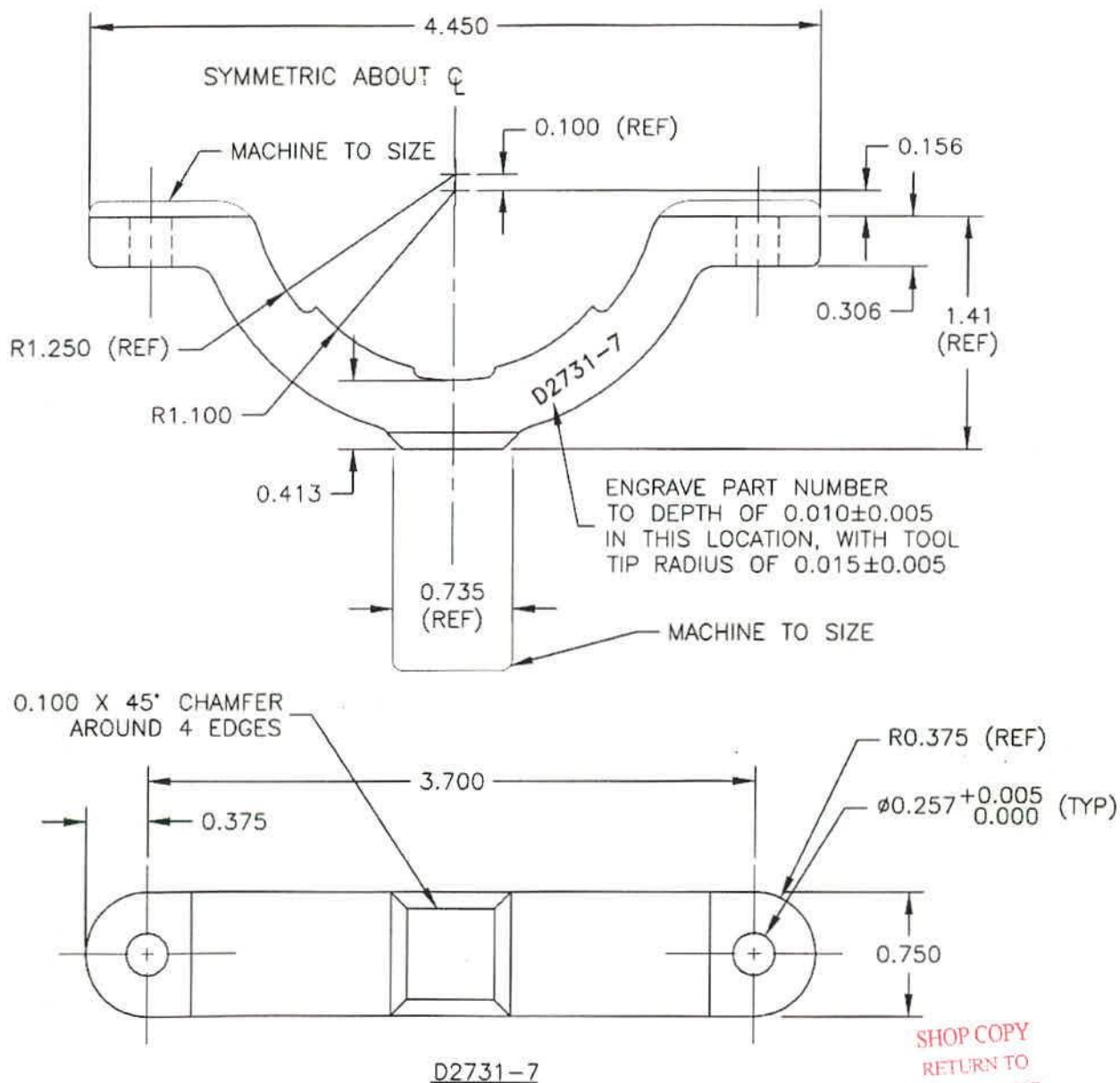
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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

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99.07.14 *KE*

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NO. 33420



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D2731-7

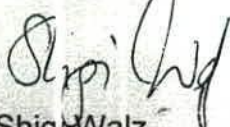
Lug B33420

4191

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Spig Walz

Vankleek Hill, August 20, 2007


Ep
1108/02



20 Terry Fox Drive
Vank eek Hill, Ontario K0B 1R0
Tel: (313) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **16102**

Date:

Aug 20, 2007

Page:

1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4191	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG B33420 MATERIAL SUPPLIED BY DART D2423 B23779	Each	100	50	50
EP 07/08/20				
Received by _____		Thank you for your order!		